

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-024339**Date Inspected:** 03-Jun-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Liu Hua Jie.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG components.**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Mr. Shailesh Wadkar was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS)

Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA Inspector observed and/or found the following:

Trial Assembly Yard:

This QA Inspector observed the following work in progress:

OBG Seg 14W:

The Flux Cored Arc Welding (FCAW) process on weld joint no: Seg3020AF-047 (X4969 I-rib stiffener to Deck Panel, fillet weld at panel point 126). The welder is identified as 045175 and was observed welding in 2F position. ZPMC Quality Control (QC) was identified as Zhu Lin. The welding variables recorded by this QC appeared to comply with welding procedure specification (WPS): B-T-2132-ESAB.

The Shielded Metal Arc Welding (SMAW) process on weld joint no: Seg3020E-016 (Sub Assembly 3146 to Floor Beam, fillet weld). The welder is identified as 069095 and was observed welding in 4F position. ZPMC QC was identified as Zhu Lin. The welding variables recorded by this QC appeared to comply with WPS: B-P-2114-FCM-1.

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The SMAW process on weld joint no: Seg3020Y-019 (Sub Assembly to Sitffener, fillet weld). The welder is identified as 067610 and was observed welding in 4F position. ZPMC QC was identified as Zhu Lin. The welding variables recorded by this QC appeared to comply with WPS: B-P-2114-FCM-1.

Repair welding of weld joint no: Seg3020Q-096 (I-rib stiffener on FB3320A to X4837L I-rib stiffener, CJP weld at PP126). The welder is identified as 068493 and was observed welding in the 1G position. Welding process was identified as SMAW. ZPMC QC was identified as Shi Lei. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-1G(1F)-FCM-Repair-1. Repair welding was done as per Welding Repair Report (WRR): 21174 Rev-0.

OBG Seg 13BW:

Repair welding of weld joint no: DP3133-001-030 (X4126D Stiffener plate to Deck Panel 3133 CJP weld at PP122). The welder is identified as 045196 and was observed welding in the 4G position. Welding process was identified as SMAW. ZPMC QC was identified as Shi Lei. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-4G(4F)-FCM-Repair-1. Repair welding was done as per Welding Repair Report (WRR): 21033 Rev-0.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable Contract documents.

Summary of Conversations:

No significant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang; phone: 15000422372., who represents the Office of Structural Materials for your project.

Inspected By:	Wadkar,Sailesh	Quality Assurance Inspector
Reviewed By:	Peterson,Art	QA Reviewer
